

What is claimed is:

- 1- A ternary solder alloy which is lead free, of high strength and particularly well suited for microelectronic applications consisting essentially of tin, silver and bismuth with tin in a major proportion, bismuth in excess of 5 wt% and up to 25 wt% and silver in a range from about 2 wt % to less than 5% silver.
- 2- A ternary solder alloy as defined in claim 1 consisting essentially of tin in a range from about 70 wt% to less than 91 wt %, bismuth in a range from about 5 wt% to 25 wt% and silver in a range from 2 wt% to 5 wt%.
- 3- A ternary solder alloy as defined in claim 2 consisting essentially of about 6.1 wt% bismuth, 3.1 wt% silver balance tin.
- 4- A ternary solder alloy as defined in claim 2 consisting essentially of about 10-15 wt% bismuth, 3.3-3.5 wt% silver, balance tin and having a controlled liquidus temperature of between about 191°C -201°C.
- 5- A microelectronic structure comprising at least two microelectronic components joined by means of a solder alloy with the solder alloy consisting essentially of tin, silver and bismuth with tin in a major proportion, bismuth in excess of 5 wt% and up to 25 wt% and silver in a range from about 2 wt% to less than 5 wt%.
- 6- A microelectronic structure as defined in claim 5 wherein said solder alloy consists essentially of from about 70 to less than 91 weight percent tin, from about 5 wt% to 25 wt% bismuth and from 2 wt% to 5 wt% silver.

7- A microelectronic structure as defined in claim 5 wherein said microelectronic components are selected from the group consisting of: chip carriers, IC chips and circuit boards.

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8- A method of joining at least two microelectronic components to one another comprising the steps of connecting the components to be joined with a ternary solder alloy consisting essentially of a major proportion of tin, between about 5 to 25 wt% bismuth and 2 to 5 wt% silver. 298

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9- A method as defined in claim 8 wherein said solder alloy consists essentially of from about 70 to less than 91 weight percent tin, from about 5 to 25 wt% bismuth and from 2 to 5 wt% silver.

10- A method as defined in claim 8 wherein said solder alloy consists essentially of about 10-15 wt% bismuth, 3.3-3.5 wt% silver, balance tin.

11- A solder paste comprising a flux, an organic vehicle and particles of metal having a composition consisting essentially of a major proportion by weight of tin, between about 5 to 25 wt% bismuth and from 2 to 5 wt% silver.

12- A solder paste as defined in claim 11 wherein said composition consists essentially of from about 70 to less than 91 weight percent tin, from about 5 to 25 wt% bismuth and from 2 to 5 wt% silver.

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13- A process for producing circuit boards, comprising the steps of:

- producing plated through holes in a circuit board;
- inserting the pins of pin-in-hole components into the plated through holes;
- producing a stationary wave of liquid solder consisting essentially of a major proportion of tin, between about 5 to 25 wt% bismuth and from 2 to 5 wt% silver;
- moving the circuit board across the wave with the bottom of the circuit board in contact with the wave, thereby substantially filling the plated through holes with solder;

and

- cooling the circuit board to form solid solder joints.

14- A process for producing circuit boards comprising the steps of:

- producing a substrate with multiple wiring layers including exposed metal pads on a surface;
- forming a solder paste comprising a flux, an organic vehicle and particles of metal consisting essentially of a major proportion of tin, bismuth in excess of 5 wt% and up to 25 wt% and from 2 to 5 wt% silver;
- depositing the solder paste upon said substrate;
- placing terminals of a surface mount component onto corresponding pads of the substrate;

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heating said solder paste to a temperature sufficient to reflow the solder paste to  
conned the component with the substrate; and  
cooling to solidify the connections.

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